



Date: Wednesday, 2/20/2008 4:18:48 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI-UTILITY BASKET RH	  08-03-17
Job Number : 37514	Part Number : D205541046	
Estimate Number : 13190	Drawing Number : IIN D205-541 REV G U/R	
P.O. Number :	Project Number :	
This Issue : 2/20/2008 S.O. No. :	Drawing Revision : G	
Prsht Rev. : NC	Material :	
First Issue : / / Type : LARGE FAB ASSY	Due Date : 3/14/2008	Qty: 1 Um: Each
Previous Run : 37487		
Written By : _____		
Checked & Approved By : _____		
Comment : Est Rev: new issue 08-02-15 verified by: _____		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD205-541-046	CHG001
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2.0	D3712042	LOW PROFILE BASKET BASE ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
LOW PROFILE BASKET BASE ASSEMBLY	mf 08-03-15

3.0	D3713042	LID ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
LID ASSEMBLY	B 37526 mf 08-03-15

4.0	D2258300	Placard
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
Placard	
Batch: 37538	AS 08/03/14 (X)

5.0	D2332041	Lid Prop Assembly 6.69"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
Lid Prop Assembly 6.69"	
Batch: 35748	AS 08/03/14 (X)

6.0	D2530	Handle Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
Handle Weldment	
Batch: 36057	AS 08/03/14 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:18:48 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37514

Part Number: D205541046

Job Number: 

Seq. #: Machine Or Operation: Description:

7.0 D2535 Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Spring
Batch: 36397

AS 08/03/14 (X)

8.0 D2537 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bushing
Batch: 36853

AS 08/03/14 (X)

9.0 D2931 Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bumper
Batch: 21139

AS 08/03/14 (X)

10.0 AN316A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bolt
Batch: M106815

AS 08/03/14 (X)

11.0 AN422A Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)
Bolt
Batch: M16895

AS 08/03/14 (X)

12.0 AN422A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Bolt
Batch: M104937

AS 08/03/14 (X)

13.0 AN424A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Bolt
Batch: M104547

AS 08/03/14 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08/03/14	11	Use AN4-20A M 16895 instead	mf	08-03-15	1	} PH 08-03-17 ASB Sub		
	2	AN9605D 416 L M 106785 instead AN9605D	mf	08-03-15	1			
		418 AN9605D 8. M 106918 (2).		08-03-15	1			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:18:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37514

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M107242

AS 08/03/14 (X)

15.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M106277

AS 08/03/14 (X)

16.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M106654

AS 08/03/14 (X)

17.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: 105442

AS 08/03/14 (X)

18.0

MS21042L3

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch: M106242

AS 08/03/14 (X)

19.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Nut

Batch: M105938

AS 08/03/14 (X)

20.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M106277

AS 08/03/14 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:18:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37514

Part Number: D205541046

Job Number: 

Seq. #: Machine Or Operation: Description:

21.0 MS20600AD4W3 Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Cherry Rivets
Batch: 18071

AS 08/03/14 (X)

22.0 D37231 FWD PLATE



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)
FWD PLATE 37900 x 4 B37530 x 2

AS 08/03/14 (X)

23.0 D37571 Blanking Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Blanking Plate 37815

AS 08/03/14 (X)

24.0 AN311A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)
Bolt M14820

AS 08/03/14 (X)

25.0 AN960JD10 Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)
Washer M106552

AS 08/03/14 (X)

26.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg.

MF 08-03-15 (1)

27.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS 08/03/17
**ENGINEERING
APPROVAL**

28.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/03/14	24	Use AW3-11A instead of AW3-10A M 11812 25 AW 9605 D 8				PA 08/03/14 per 255042	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37514

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

D21991

Struts, 19"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Struts, 19"
Batch: 28996

30.0

D219923

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Strut
Batch: 29387

31.0

D219925

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Strut
Batch: 329131

32.0

D2498

Mounting Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Mounting Bracket
Batch: 17625

33.0

D2499

Mounting Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Mounting Bracket
Batch: 27501

34.0

D2515

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bushing
Batch: 29138

35.0

D30521

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Mounting Lug
Batch: 28522

B28522 10/3/170

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:18:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37514

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M102140

37.0

AN412A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Batch: M105143

38.0

AN413A

Bolt



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Bolt

Batch: M106993

39.0

AN414A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M105653

40.0

AN57A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M106785

41.0

AN513A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M104936

42.0

AN960JD416

Washer



Comment: Qty.: 27.0000 Each(s)/Unit Total : 27.0000 Each(s)

Washer

M106277

EC 8/3/19 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: 12 Date: 09/03/17

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:18:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37514

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description:

43.0

AN960JD516

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Washer

Batch: M106654

44.0

MS21042L4

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut

Batch: M105538

45.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: M106277

46.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-541-044

Location:

PPP Rev:

48.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 08.02.21 AUTH L
RELEASED 14 DATE 08.03.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

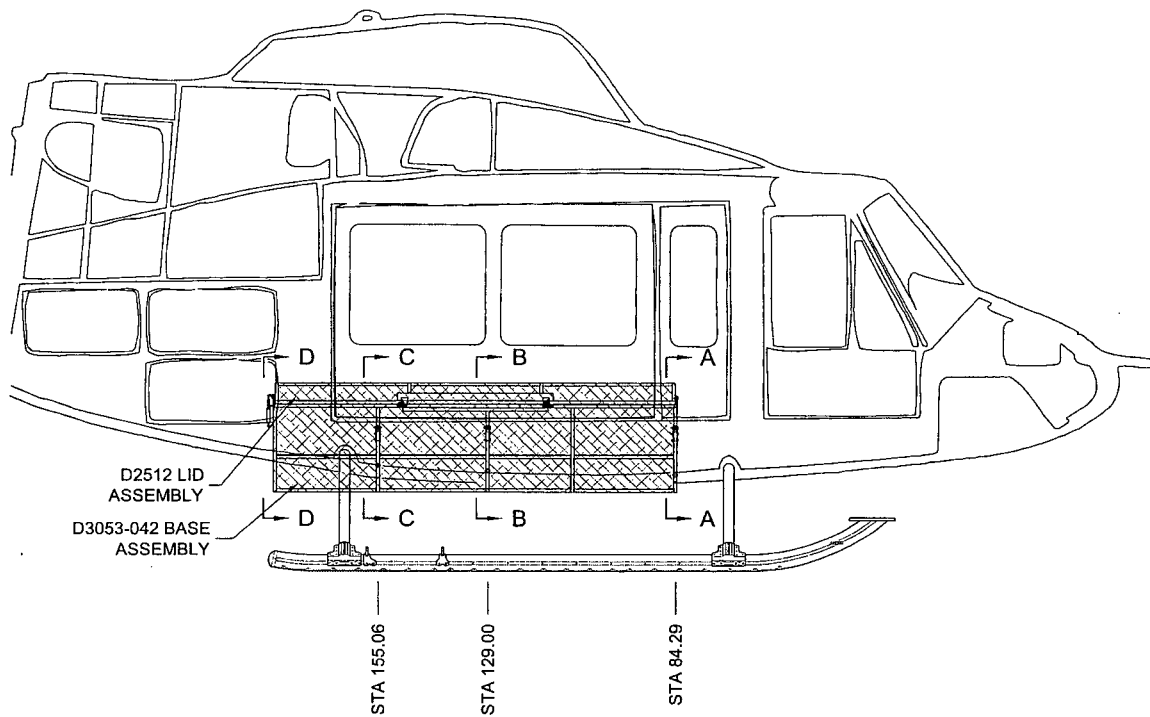


Figure 1a - D205-541-044 Heli-Utility-Basket™ - Side View Shown
(D205-541-043 Opposite)

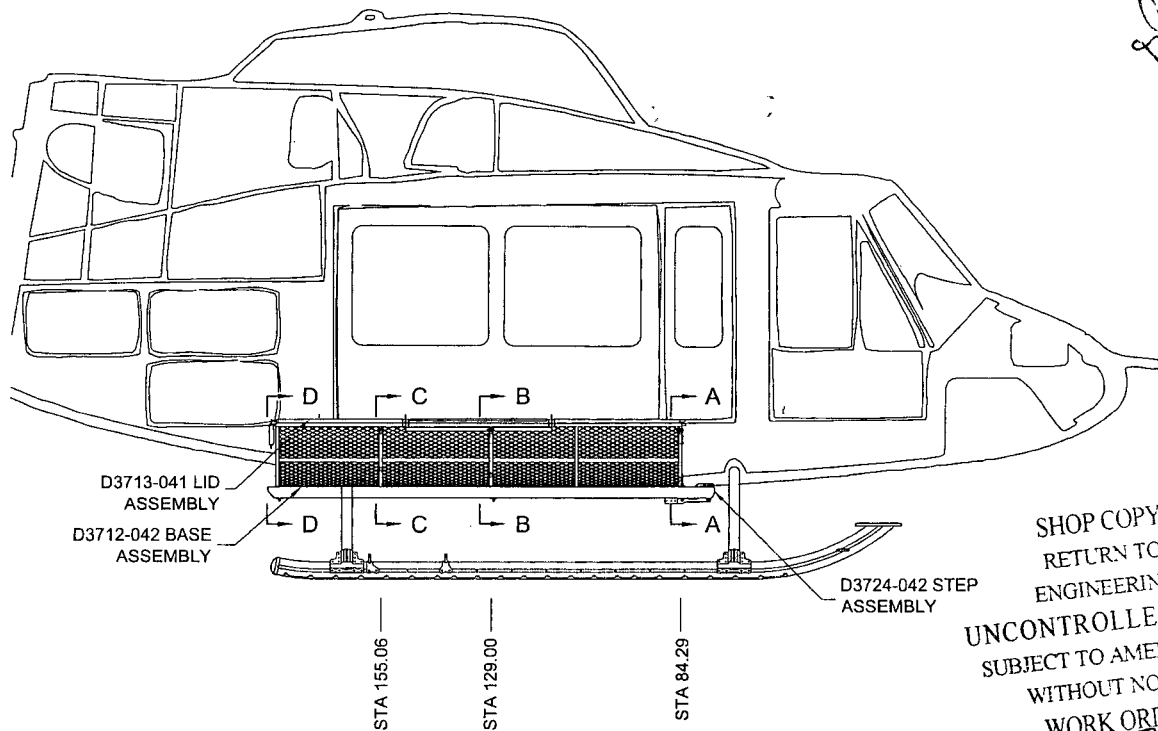


Figure 1b - D205-541-046 Heli-Utility-Basket™ - Side View Shown
(D205-541-045 Opposite)

PRELIMINARY ISSUE
ASS 02.21.08

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WORK ORDER
NO. 37514

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Revision: **G**
Date: 08.02.04

- 3.2.4 Reposition the step assembly with the basket and install as shown in Figure 12. Torque the #10 fasteners to 15-25 in-lbs (N-m).

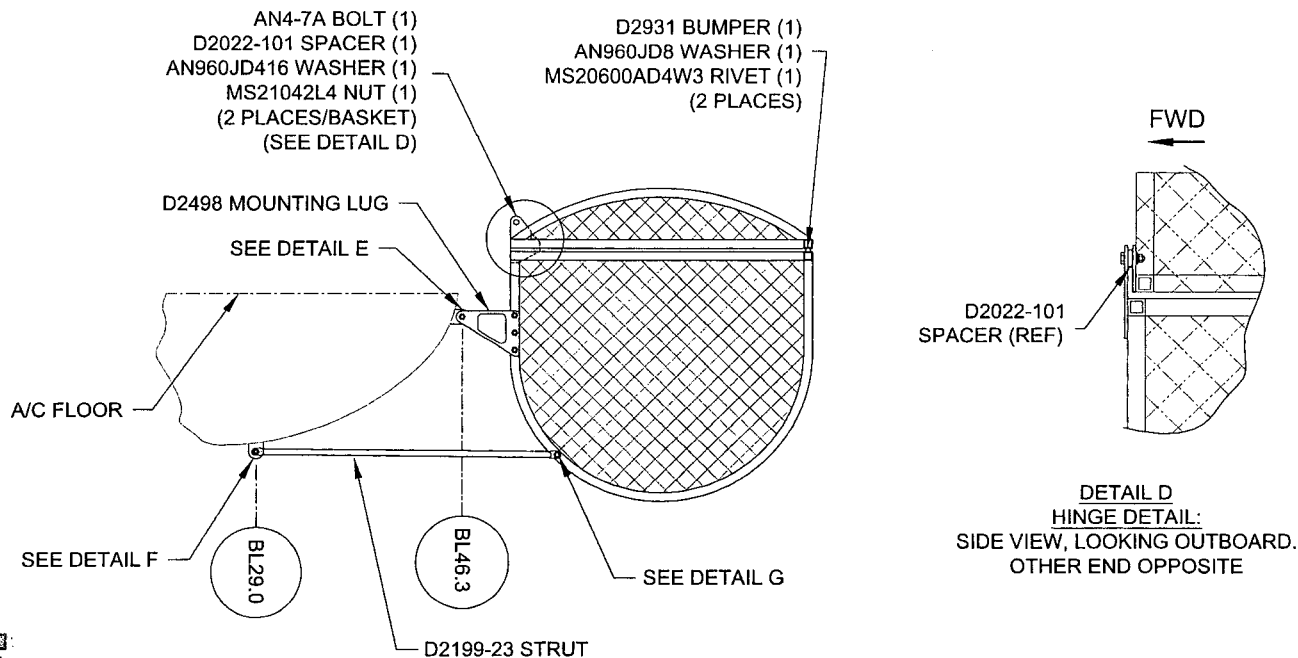


Figure 2a - Section A-A Looking Fwd at STA 84.29
(D205-541-044 Shown; D205-541-043 Opposite)

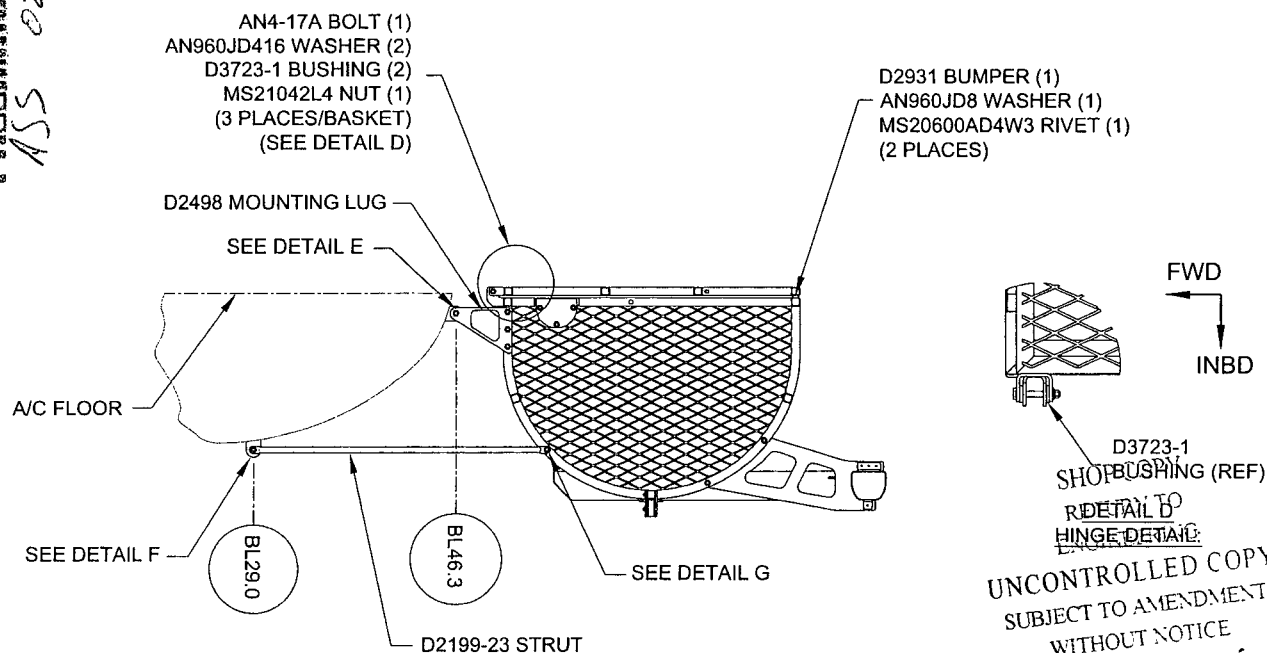


Figure 2B - Section A-A Looking Fwd at STA 84.29
(D205-541-046 Shown; D205-541-045 Opposite)

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Revision: **G**

Date: 08.02.04

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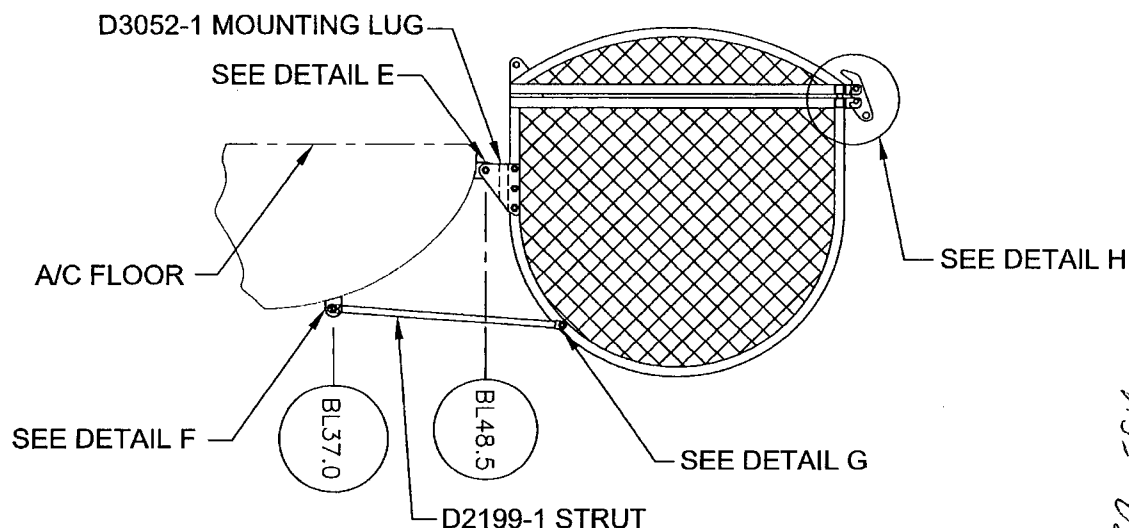


Figure 3a – Section B-B Looking Fwd at STA 129.00
(D205-541-044 Shown; D205-541-043 Opposite)

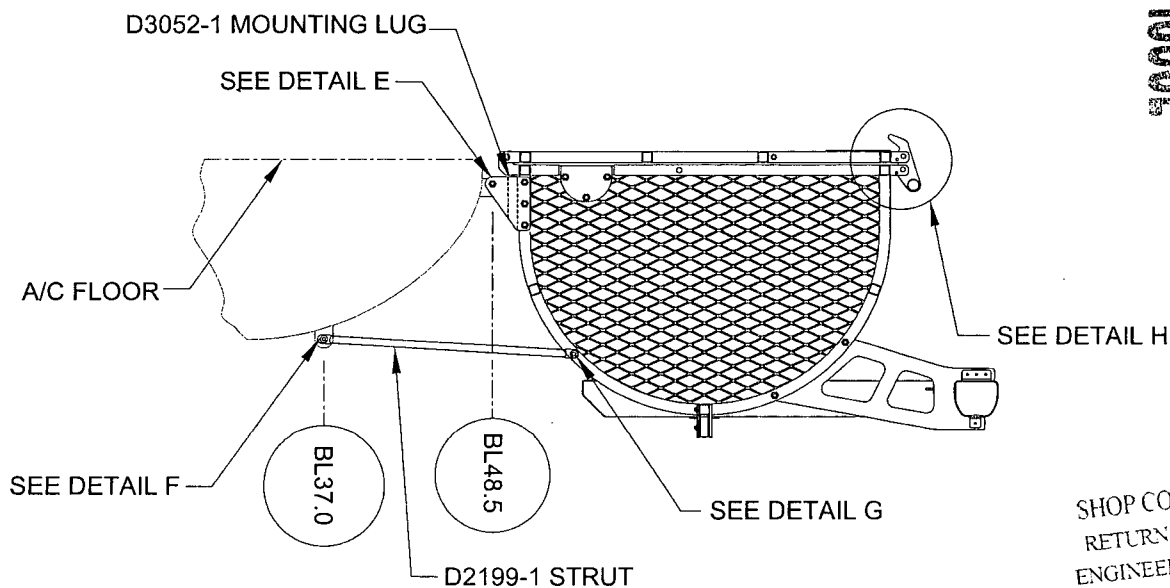


Figure 3b – Section B-B Looking Fwd at STA 129.00
(D205-541-046 Shown; D205-541-045 Opposite)

AS

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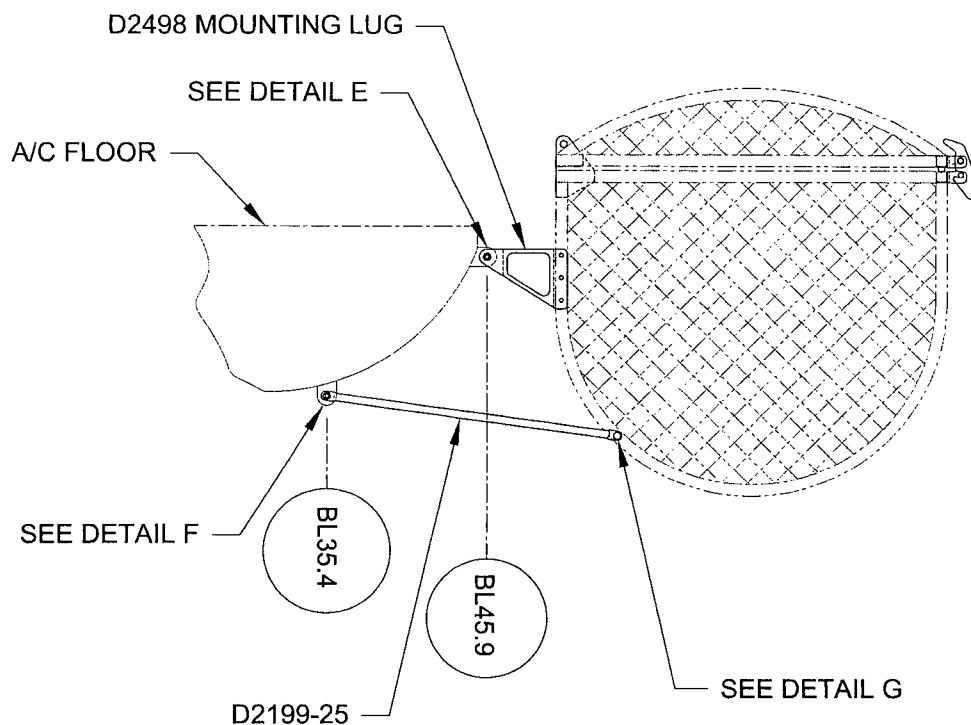


Figure 4a – Section C-C Looking Fwd at STA 155.06

(D205-541-044 Shown; D205-541-043 Opposite)

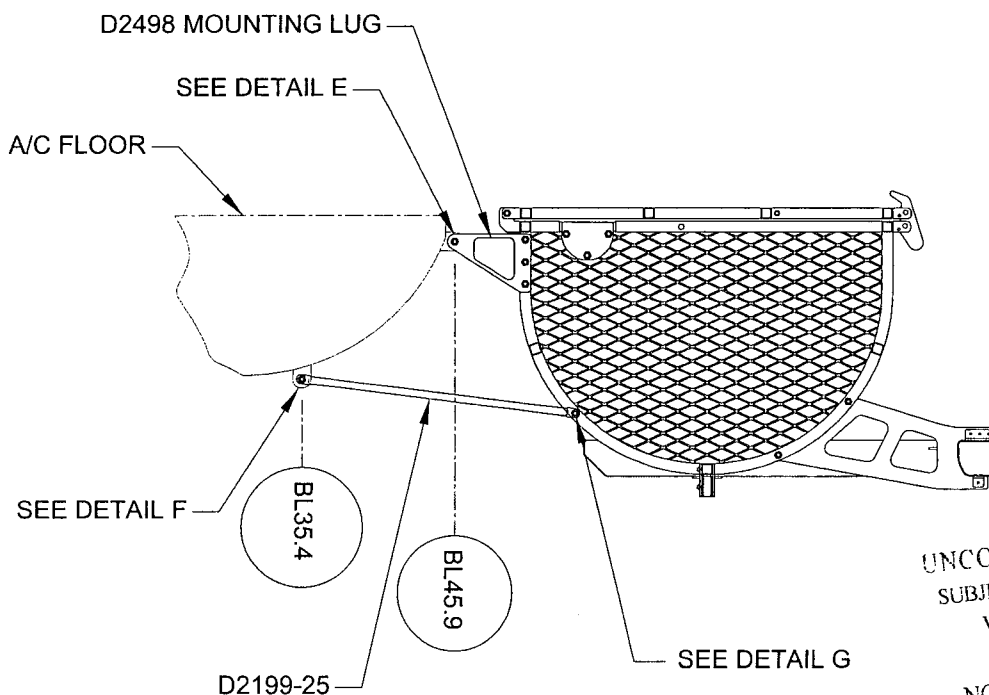


Figure 4b – Section C-C Looking Fwd at STA 155.06

(D205-541-046 Shown; D205-541-045 Opposite)

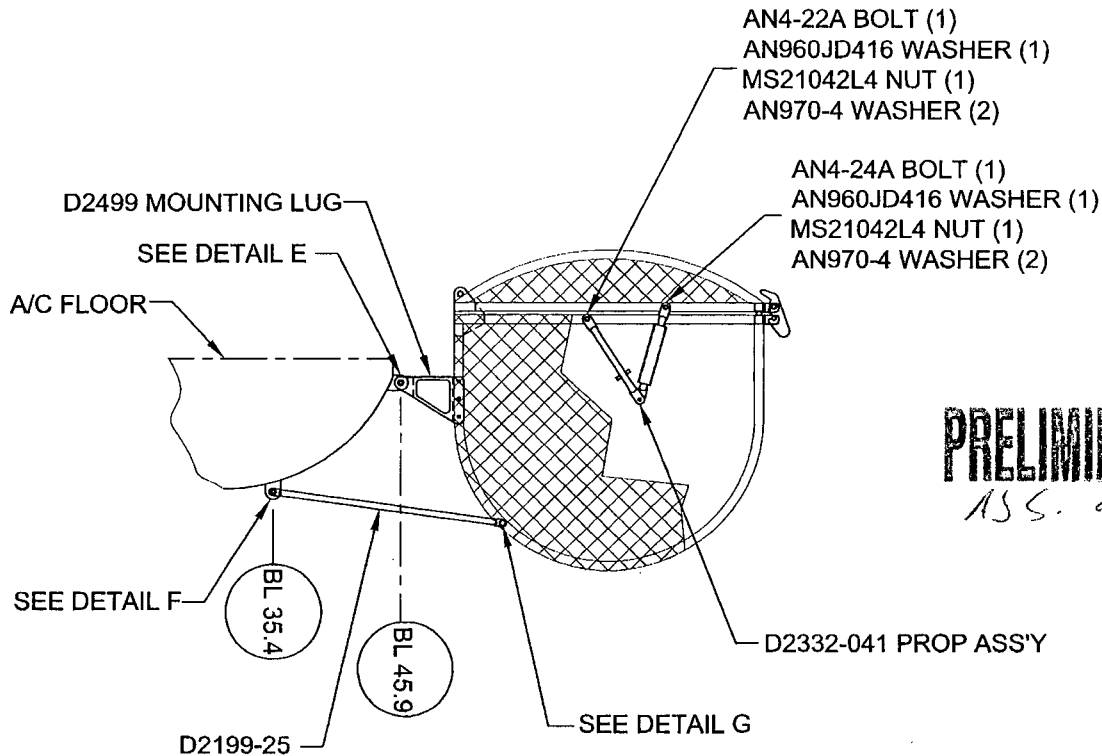
PRELIMINARY ISSUE
155 02.21.08

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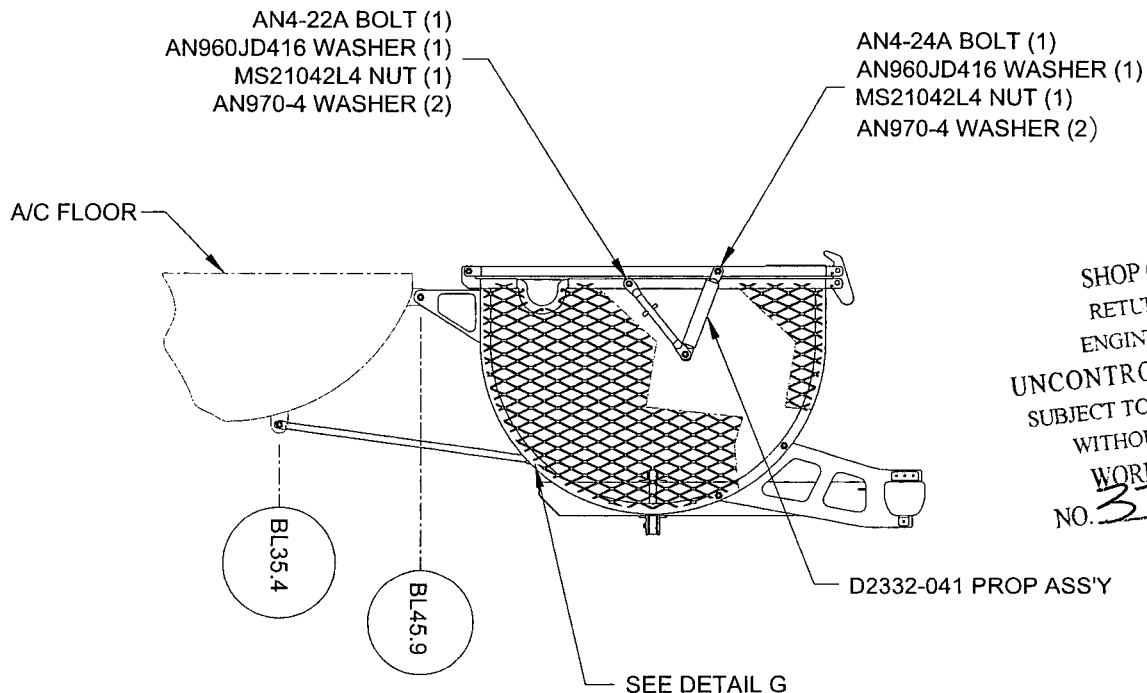
Revision: **G**

Date: 08.02.04



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Figure 4a – Section C-C Looking Fwd at STA 180.08
(D205-541-044 Shown; D205-541-043 Opposite)



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Figure 4b – Section C-C Looking Fwd at STA 180.08
(D205-541-046 Shown; D205-541-045 Opposite)

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Revision: **G**
Date: 08.02.04

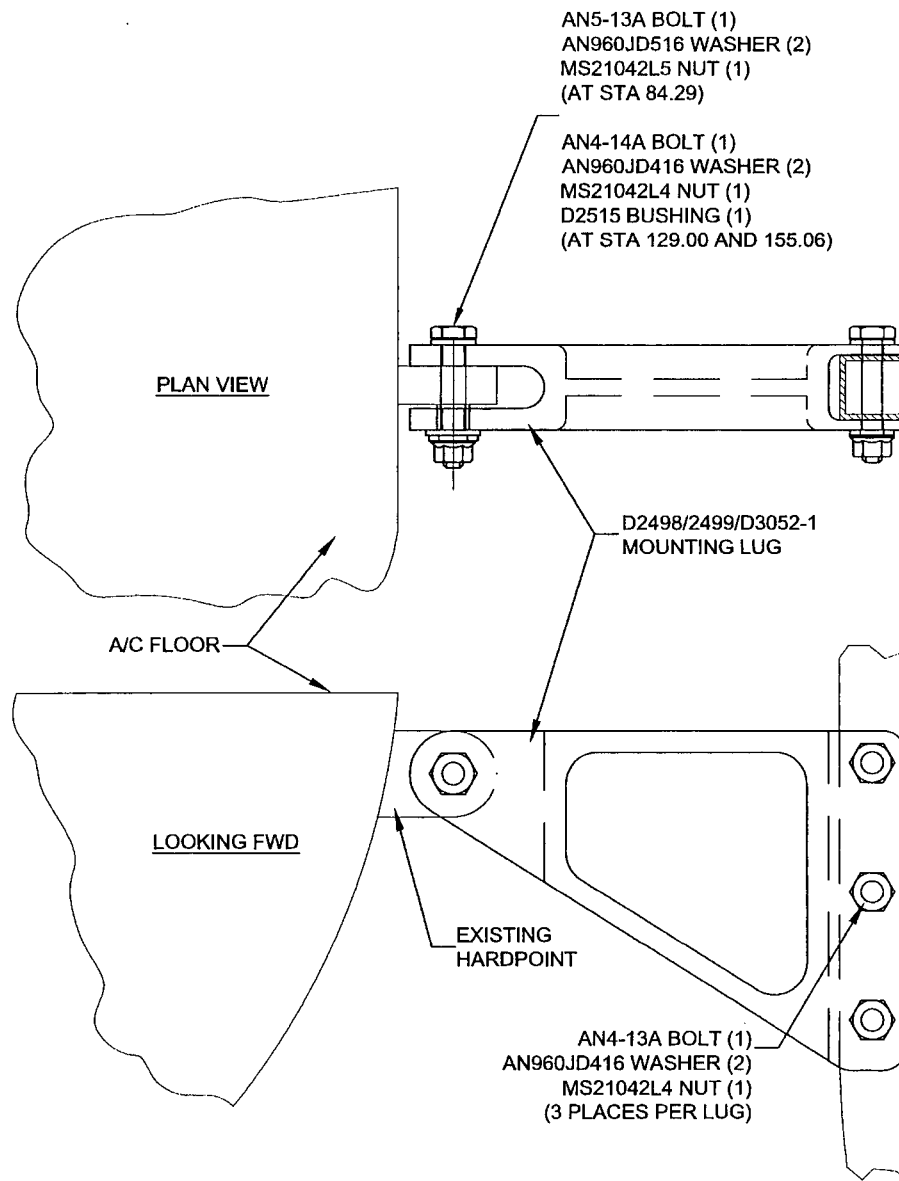


Figure 5 – Detail 'E' Mounting Lug Installation

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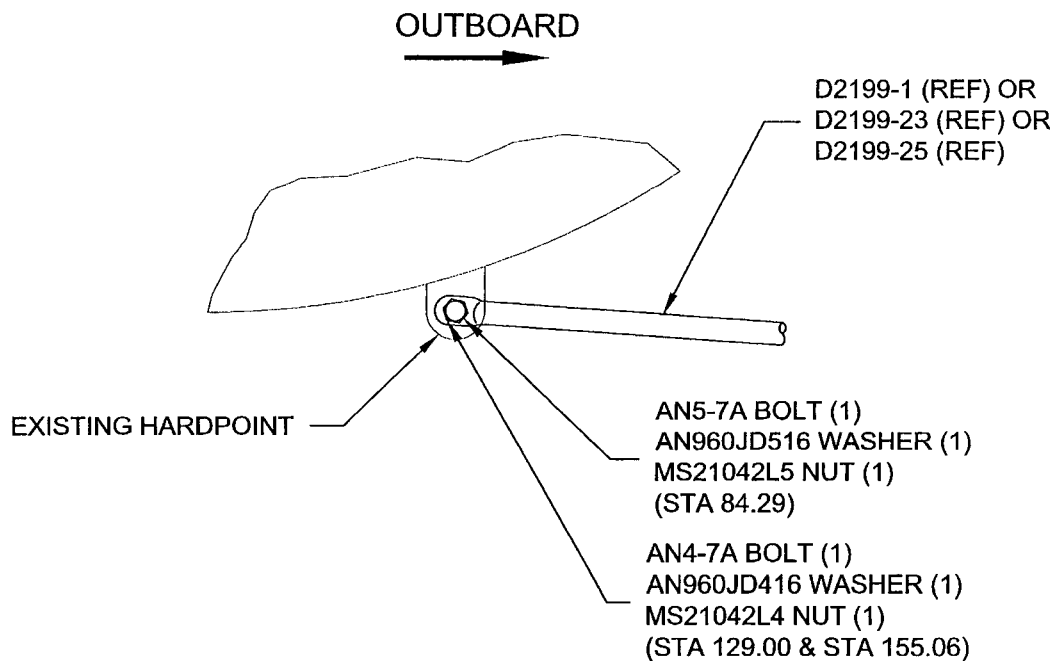


Figure 6 – Detail 'F' Strut to Hardpoint Attachment

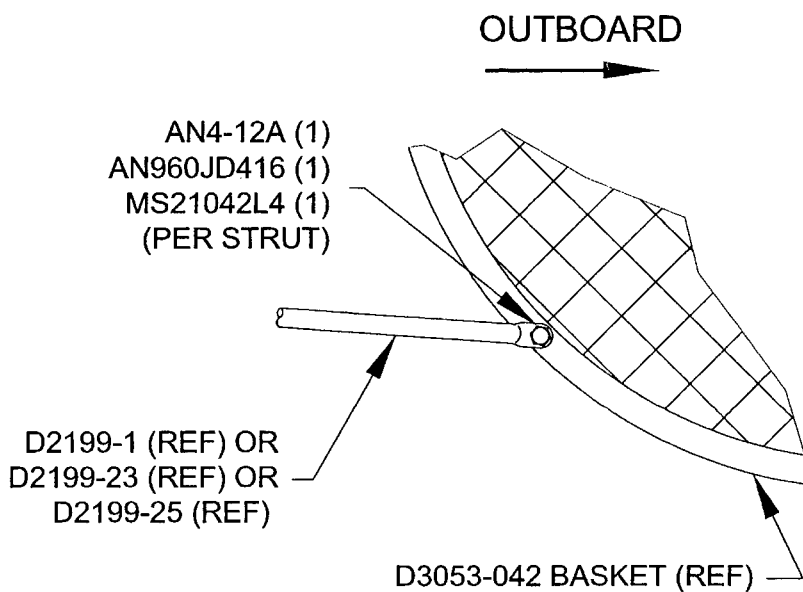


Figure 7 – Detail 'G' Strut to Basket Attachment

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AS 02.21.04

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NO. 37514

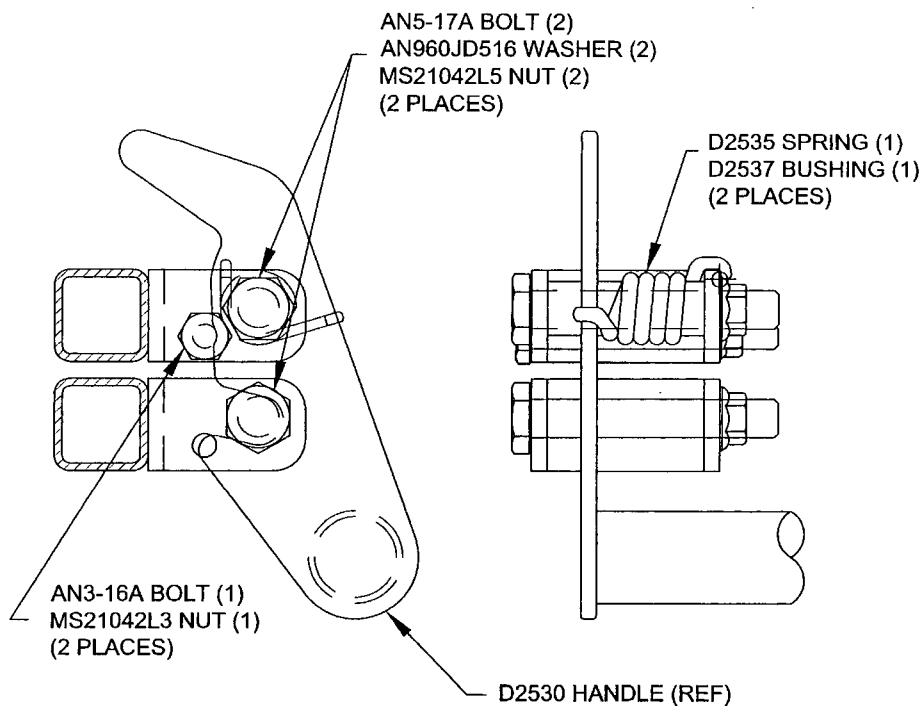


Figure 8 – Detail 'H' Handle Assembly

Figure 9 – Mesh Removal

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ASS 02.21.08

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WORK ORDER
NO. 37514

Date: Wednesday, 2/20/2008 4:18:48 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI-UTILITY BASKET RH
Job Number : 37514	
Estimate Number : 13190	
P.O. Number :	Part Number : D205541046
This Issue : 2/20/2008 S.O. No. :	Drawing Number : IIN D205-541 REV G U/R
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : G
Previous Run : 37487	Material :
Written By :	Due Date : 3/14/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est Rev:A new issue 08-02-15 verified by:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD205-541-046 CHG001

2.0	D3712042	LOW PROFILE BASKET BASE ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
LOW PROFILE BASKET BASE ASSEMBLY

3.0	D3713042	LID ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
LID ASSEMBLY

4.0	D2258300	Placard
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Placard
Batch: _____

5.0	D2332041	Lid Prop Assembly 6.69"
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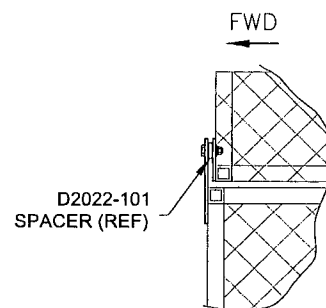
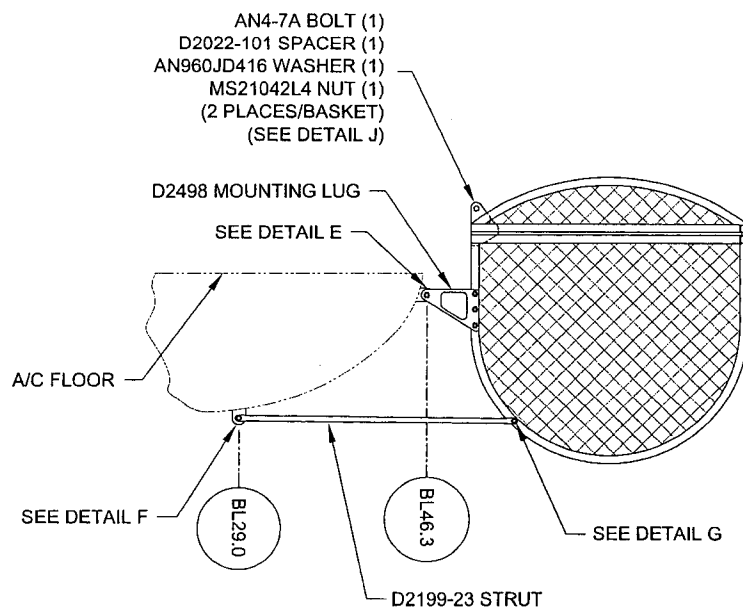
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lid Prop Assembly 6.69"
Batch: _____

6.0	D2530	Handle Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Handle Weldment
Batch: _____

REFERENCE ONLY



DETAIL J
HINGE DETAIL:
SIDE VIEW, LOOKING OUTBOARD.
OTHER END OPPOSITE

Figure 2a - Section A-A Looking Fwd at STA 84.29

(D205-541-044 Shown; D205-541-043 Opposite)

RELEASED
03.03.17
A

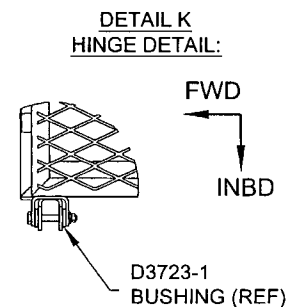
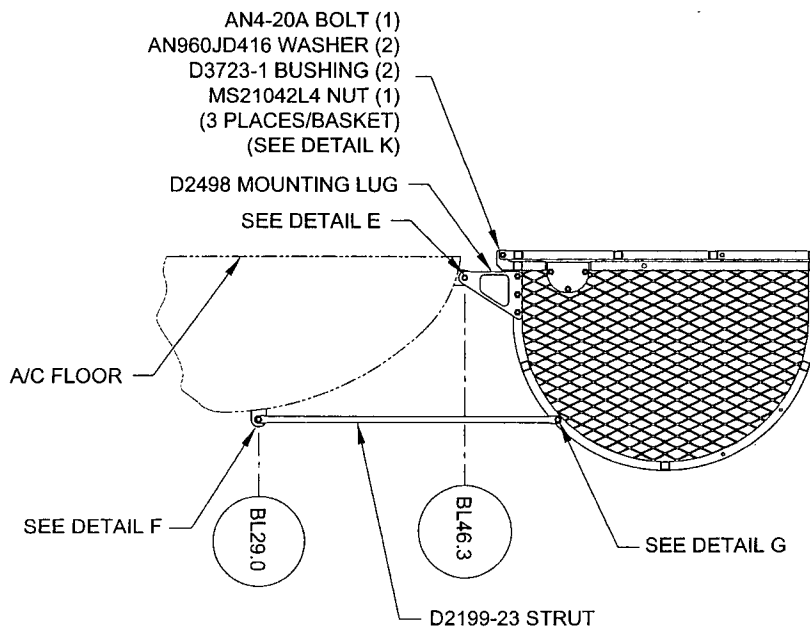


Figure 2b - Section A-A Looking Fwd at STA 84.29

(D205-541-046 Shown; D205-541-045 Opposite)

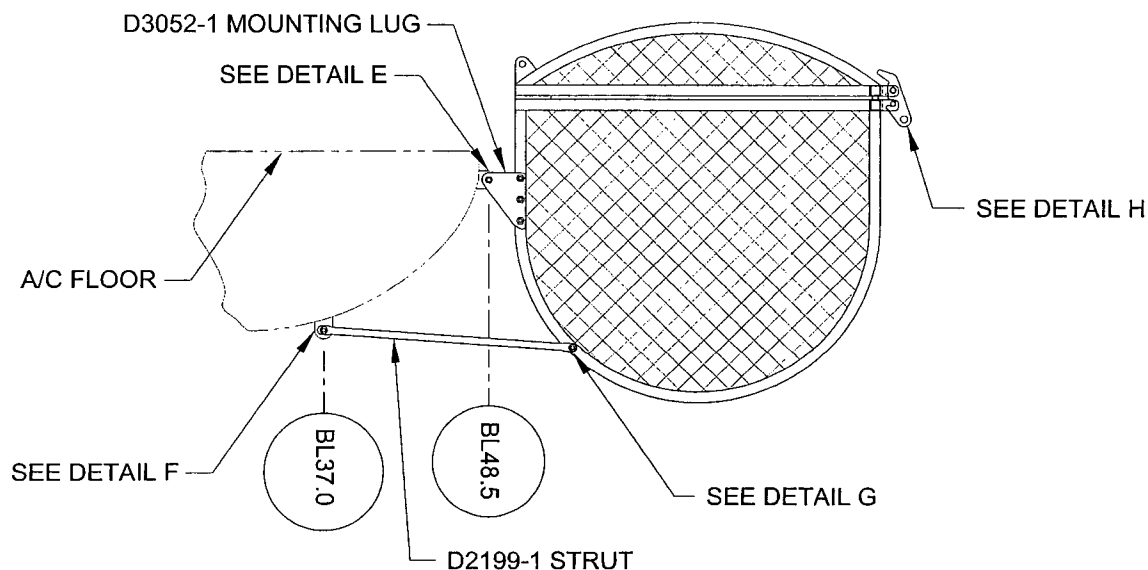


Figure 3a – Section B-B Looking Fwd at STA 129.00
(D205-541-044 Shown; D205-541-043 Opposite)

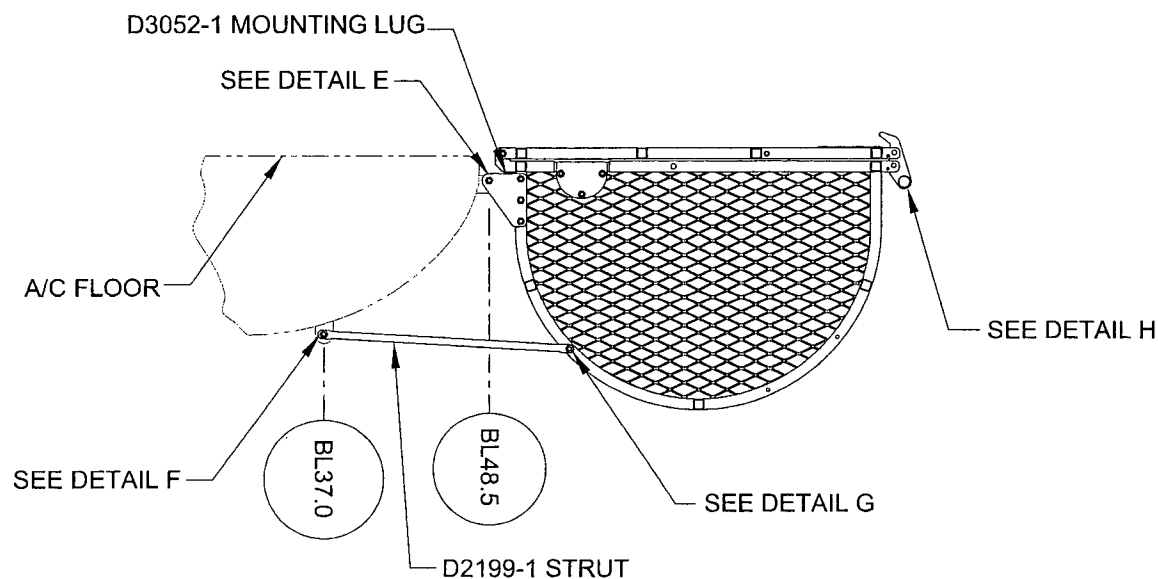


Figure 3b – Section B-B Looking Fwd at STA 129.00
(D205-541-046 Shown; D205-541-045 Opposite)

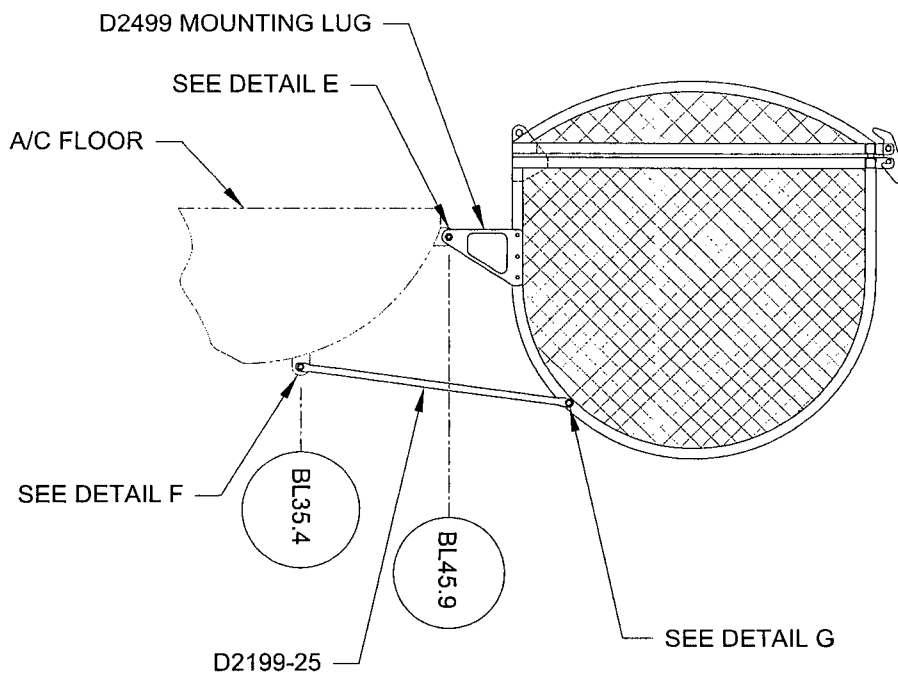


Figure 4a – Section C-C Looking Fwd at STA 155.06

(D205-541-044 Shown; D205-541-043 Opposite)

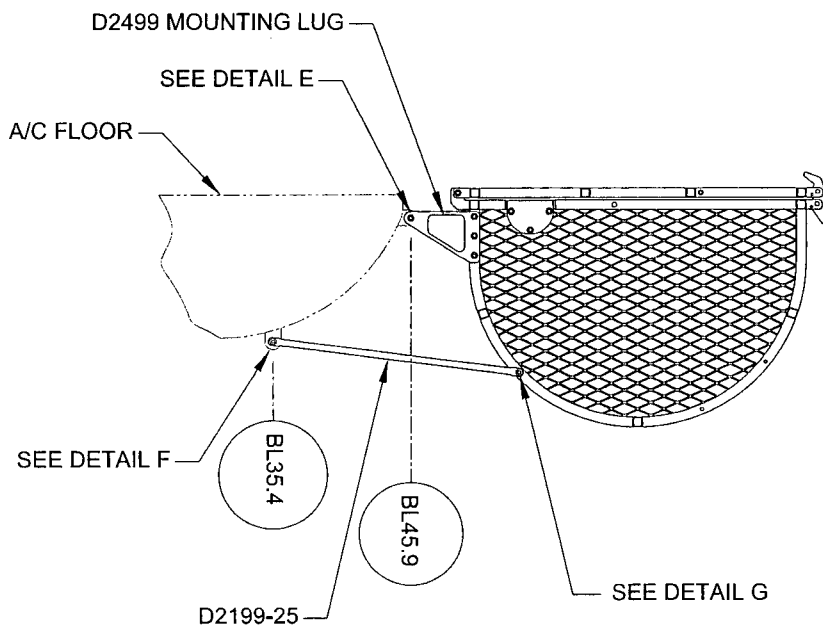


Figure 4b – Section C-C Looking Fwd at STA 155.06

(D205-541-046 Shown; D205-541-045 Opposite)

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Revision: **G**

Date: 08.03.04

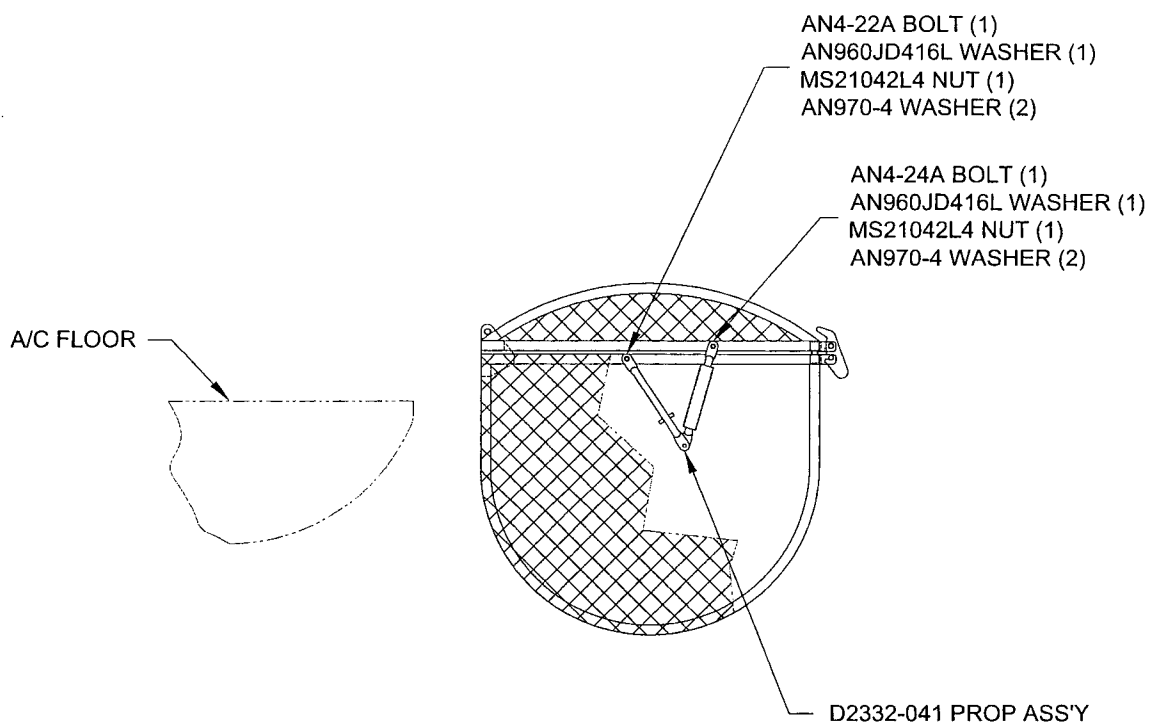


Figure 5a – Section D-D Looking Fwd at STA 180.08
(D205-541-044 Shown; D205-541-043 Opposite)

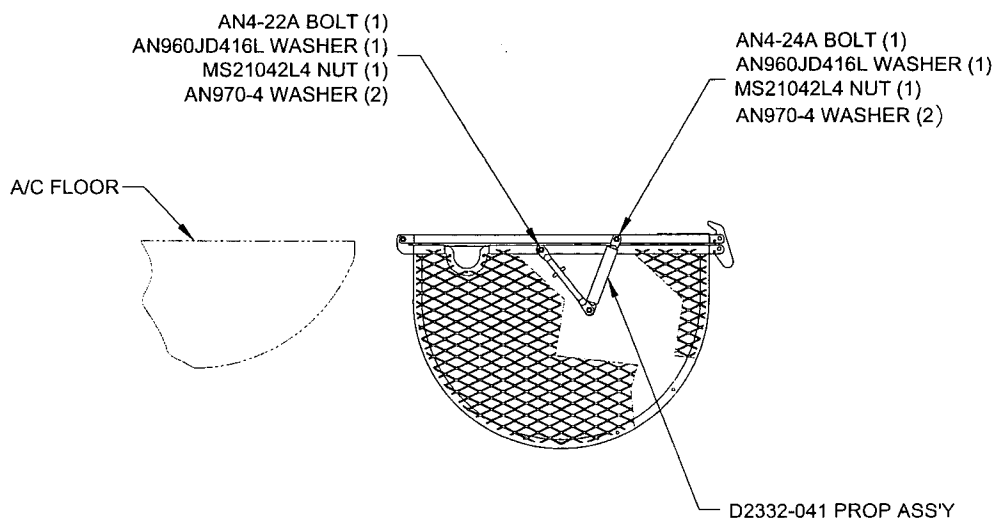


Figure 5b – Section D-D Looking Fwd at STA 180.08
(D205-541-046 Shown; D205-541-045 Opposite)

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Date: 08.03.04

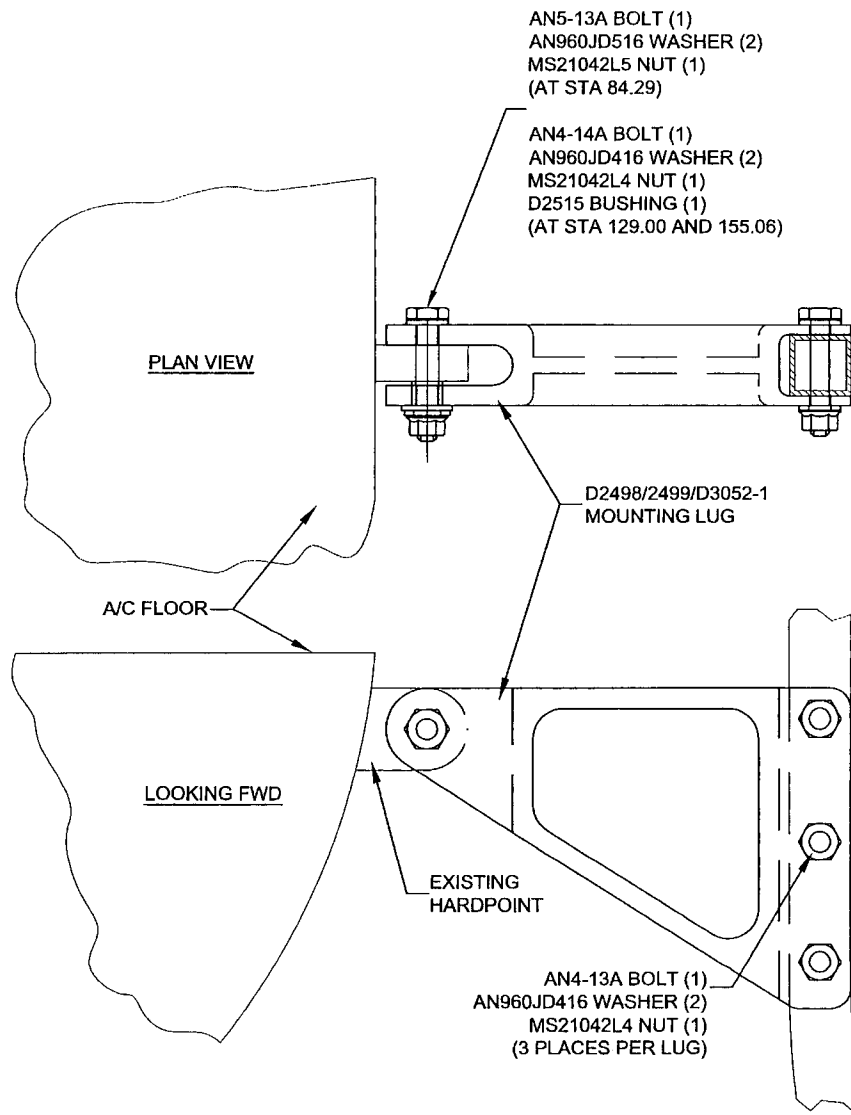


Figure 6 – Detail 'E' Mounting Lug Installation

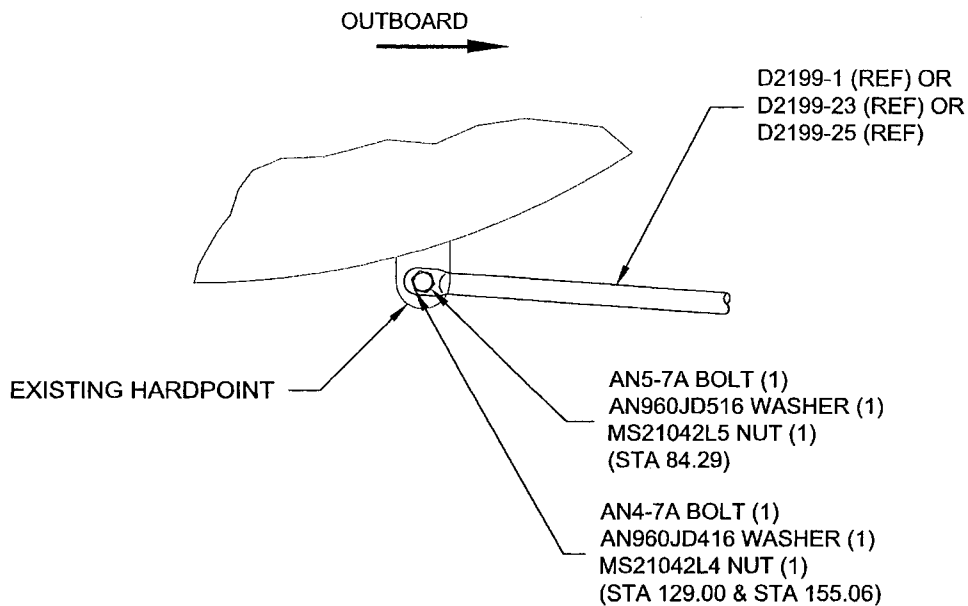


Figure 7 – Detail 'F' Strut to Hardpoint Attachment
(D205-541-044 & D205-541-046 Shown; D205-541-043 & D205-541-045 Opposite)

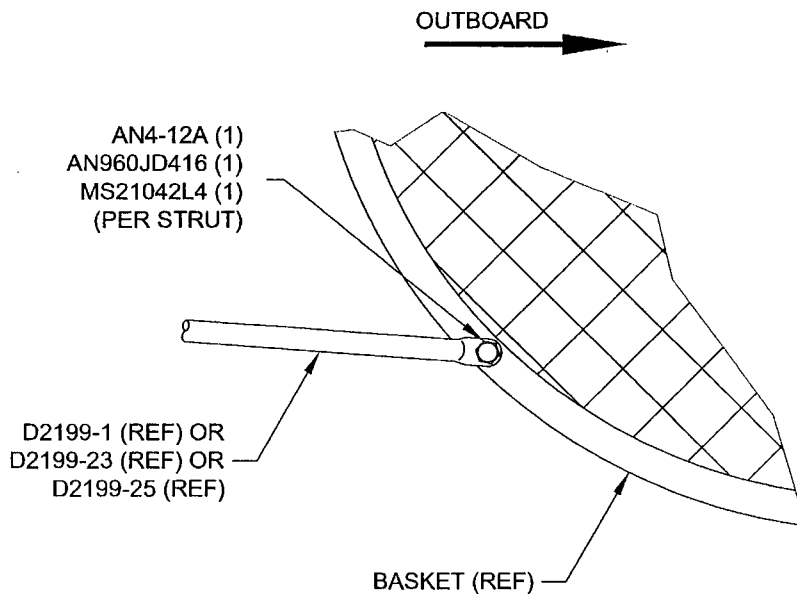


Figure 8 – Detail 'G' Strut to Basket Attachment
(D205-541-044 & D205-541-046 Shown; D205-541-043 & D205-541-045 Opposite)

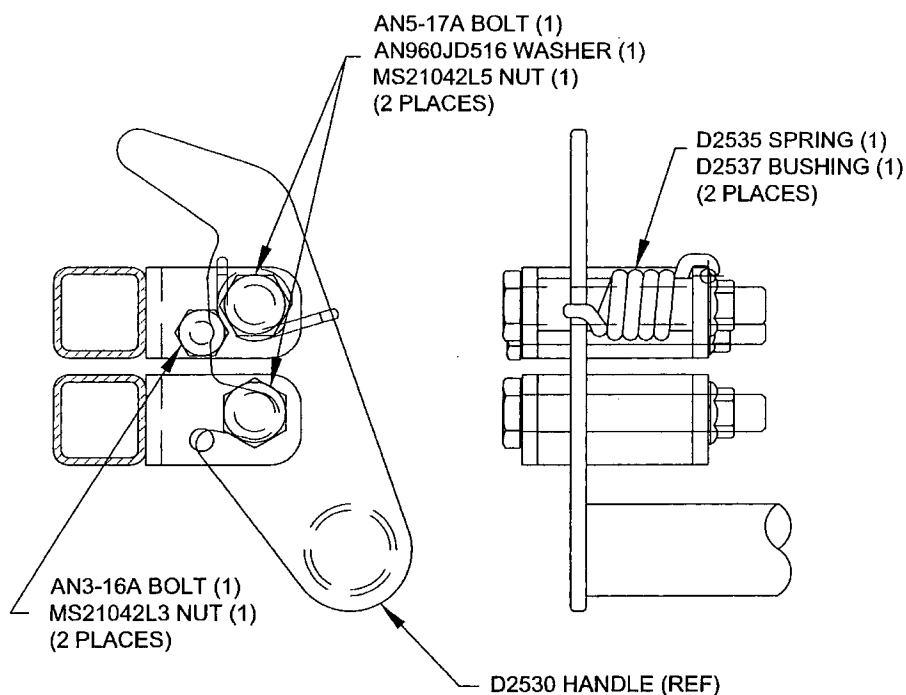


Figure 9 – Detail 'H' Handle Assembly

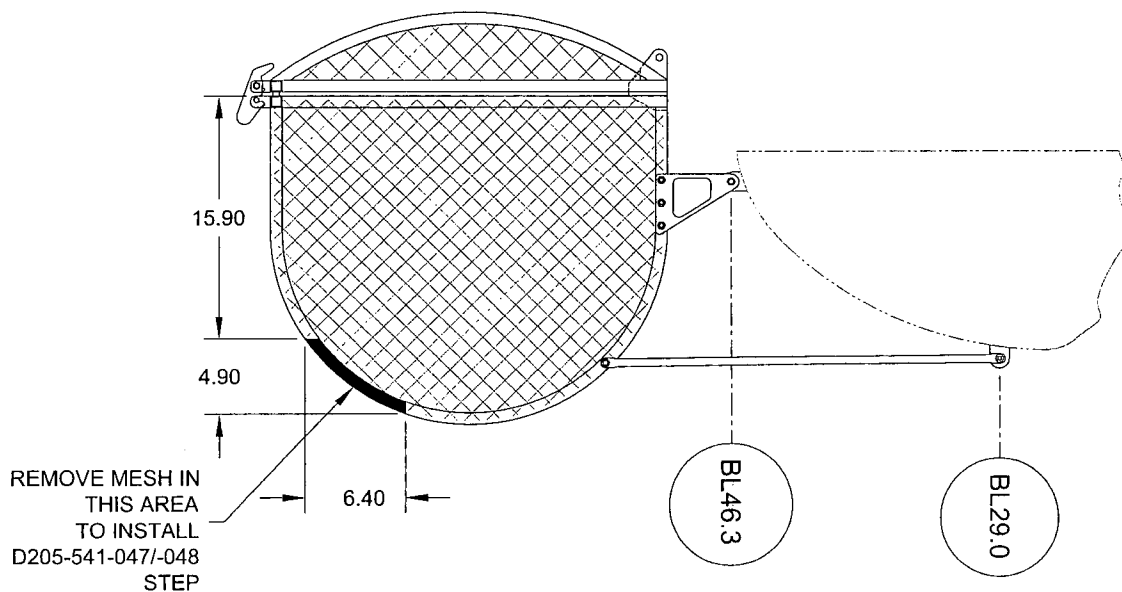


Figure 10 – Mesh Removal Looking Aft at STA 84.00
(D205-541-044 Shown; D205-541-043 Opposite)